

# Work Order ID 53321

October 30, 2009 10:18:10 AM



Page 1

Item ID: D412-630-031

Accept



Setup Start



Revision ID: M

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 30/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: PL Date: 09-10-30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy D412-630 bluefile & type labels per PPP412-630-031 LCH6001

CHG003 809/11/18

PER ECN 08-646

809/11/18

110



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per dwg D412-630 p.17 \*\*\*\*ensure tension to retract step is 11 to 18 lbs before installing lockwire.\*\*\*\*

809/11/18

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

\*\*\*\*ensure tension to retract step is 11 to 18 lbs \*\*\*\*

27 809/11/18

41

**Work Order ID 53321**

October 30, 2009 10:18:10 AM



Page 2

Item ID: D412-630-031

Accept



Setup Start



Revision ID: M

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 30/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Pick Kit	0.00							
Packaging	Memo	0.00				9/11/23	ⓧ	ⓧ	
Packaging									
140 	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00				ⓧ	ⓧ		
Quality Control									
150 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-031								
	Location: _____								
	□ PPP Rev: _____								

**Work Order ID 53321**

October 30, 2009 10:18:10 AM



Page 3

Item ID: D412-630-031

Accept



Setup Start



Revision ID: M

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 30/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/25

09/11/24

①

# Picklist Print

October 30, 2009 10:18:15 AM

Page 1  
11

Work Order ID: 53321

Parent Item: D412-630-031RevM

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN310-4 NUT		Purchased	No				Each	84.0000	1.0000			
----------------	--	-----------	----	--	--	--	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

84

110098

34

112969

50

AN310-4 NUT		Purchased	No				Each	84.0000	1.0000			
----------------	--	-----------	----	--	--	--	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

84

110098

34

112969

50

AN310-5 NUT		Purchased	No				Each	32.0000	2.0000			
----------------	--	-----------	----	--	--	--	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

32

105280

2

110552

2

111060

28

# Picklist Print

Page 2

October 30, 2009 10:18:15 AM

Work Order ID: 53321



Parent Item: D412-630-031RevM



Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN310-7 		Purchased	No				Each	39.0000	1.0000			
NUT												

*ES09/11/12*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

39

103286

19

111916

20

*21*

AN3C5A

Purchased

No

Each

546.0000

3.0000



*9/11/23 @ SL*

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

546

111424

8

111707

69

112314

1

112641

468

*3050*

# Picklist Print

October 30, 2009 10:18:15 AM

Work Order ID: 53321

Parent Item: D412-630-031RevM

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN44-C12 eyebolt		Purchased	No				Each	35.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	35	
111176	15	
111888	20	

AN4C14 BOLT		Purchased	No				Each	23.0000	1.0000			
----------------	--	-----------	----	--	--	--	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	23	
110552	23	

AN4C15 BOLT		Purchased	No				Each	16.0000	1.0000			
----------------	--	-----------	----	--	--	--	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
111303	16	

# Picklist Print

October 30, 2009 10:18:15 AM

Work Order ID: 53321

Parent Item: D412-630-031RevM

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)




Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4CH3  SS Bolt		Purchased	No				Each	42.0000	2.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>42</div> <div>111261</div> <div>7</div> <div>111978</div> <div>35</div> <div>Loc Qty</div> <div>Loc Code</div>												
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>31</div> <div>103248</div> <div>11</div> <div>111279</div> <div>20</div> <div>Loc Qty</div> <div>Loc Code</div>												
AN5C11  BOLT		Purchased	No				Each	31.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>31</div> <div>103248</div> <div>11</div> <div>111279</div> <div>20</div> <div>Loc Qty</div> <div>Loc Code</div>												
AN5C15  BOLT		Purchased	No				Each	33.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>33</div> <div>10121</div> <div>2</div> <div>110552</div> <div>31</div> <div>Loc Qty</div> <div>Loc Code</div>												

9/30/11/12

2

1.0000

9/11/23

SP

1x50

1.0000

9/11/23

SP

Q

1x50

# Picklist Print

October 30, 2009 10:18:15 AM

Work Order ID: 53321

Parent Item: D412-630-031RevM

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10 WASHER		Purchased	No				Each	293.0000	7.0000		9/11/23	SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

293

111965

293

Each

225.0000

1.0000

7x54

9/11/23

SP

AN960C516

Purchased

No

WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

225

102842

125

112532

100

Each

0.0000

1.0000

1x54

9/509/11/12

9/509/11/12

9/509/11/12

D3443-041RevC

Manufactured

No

Strut Weldment Assembly

D3443-043RevC

Manufactured

No

Strut Weldment Assembly

D3443-9RevC

Manufactured

No

Pin

B53326

Each

0.0000

1.0000

B53325

Each

0.0000

2.0000

B48124

2x

1x



# Picklist Print

October 30, 2009 10:18:15 AM

Work Order ID: 53321

Parent Item: D412-630-031RevM

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3454-1RevB Bushing		Manufactured	No				Each	14.0000	1.0000		9/11/23	sp

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
44588	2	
46135	12	

D3454-3RevB Bushing		Manufactured	No				Each	46.0000	2.0000		9/11/23	sp
------------------------	--	--------------	----	--	--	--	------	---------	--------	--	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	46	
48125	46	

D3454-5RevB Bushing		Manufactured	No				Each	13.0000	2.0000		9/11/23	sp
------------------------	--	--------------	----	--	--	--	------	---------	--------	--	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
46137	13	

# Picklist Print

Page 7

October 30, 2009 10:18:15 AM

Work Order ID: 53321

Parent Item: D412-630-031RevM

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)




Comments:

Start Date: 30/10/2009

Required Date: 16/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3454-7RevB  Bushing		Manufactured	No				Each	24.0000	2.0000			
				<u>Warehouse</u> <u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				24				
				46132				24				
D3455-1RevA  Spacer		Manufactured	No				Each	67.0000	2.0000			
				<u>Warehouse</u> <u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				67				
				46138				67				
6 D3455-1RevA  Spacer		Manufactured	No				Each	67.0000	4.0000			
				<u>Warehouse</u> <u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				67				
				46138				67				

*Ep 09/11/12*

*#2*  
*Ep 09/11/12*

*#2*  
*9/11/23* *(10 SP)*

*4x50*

# Picklist Print

October 30, 2009 10:18:15 AM

Work Order ID: 53321

Parent Item: D412-630-031RevM

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3455-3RevA

Manufactured

No

Each

41.0000

2.0000



Spacer

9/11/23 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

46139

3

48126

38

Each

3.0000

1.0000

D3462-041RevC

Manufactured

No



Bracket Assembly

2x50

9/11/23 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

46140

1

46462

2

Each

0.0000

1.0000

D3463-041RevB

Manufactured

No



Step Weldment Assembly

1x50

B53585 9/11/23 @80

# Picklist Print

October 30, 2009 10:18:15 AM

Work Order ID: 53321



Parent Item: D412-630-031RevM



Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)


Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3465-1RevB  Washer		Manufactured	No				Each	69.0000	1.0000			

9509/11/12

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

69

41692

7

46134

62

8 MS21043-3



Nut

Purchased

No

Each

5,079.000 3.0000



9/11/23 @ 54

Warehouse  
Location

Loc Qty

Loc Code

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

4999

111819

78

112243

39

112314

4882

3x50

# Picklist Print

October 30, 2009 10:18:15 AM

Work Order ID: 53321



Parent Item: D412-630-031RevM



Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS24665-227

Purchased

No

Each

32.0000

1.0000



COTTER PIN

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

111359

32

Each

32.0000

2.0000

MS24665-227

Purchased

No



COTTER PIN

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

111359

32

Each

278.0000

2.0000

MS24665-229

Purchased

No



COTTER PIN

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

278

111041

278

# Picklist Print

Page 11

October 30, 2009 10:18:15 AM

Work Order ID: 53321

Parent Item: D412-630-031RevM

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)


Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24665-302  Cotter Pin		Purchased	No				Each	33.0000	1.0000			

*9/30/11/12*

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

33

111359

33

Each

300.0000

1.0000



1

*9/11/23*

*QSD*

Warehouse  
Location

Loc Qty

Loc Code

OFFSHORE

FG

44

103286

17

103691

27

Main Warehouse

ST

256

109430

256

1 *SP*

8 NAS1515H5

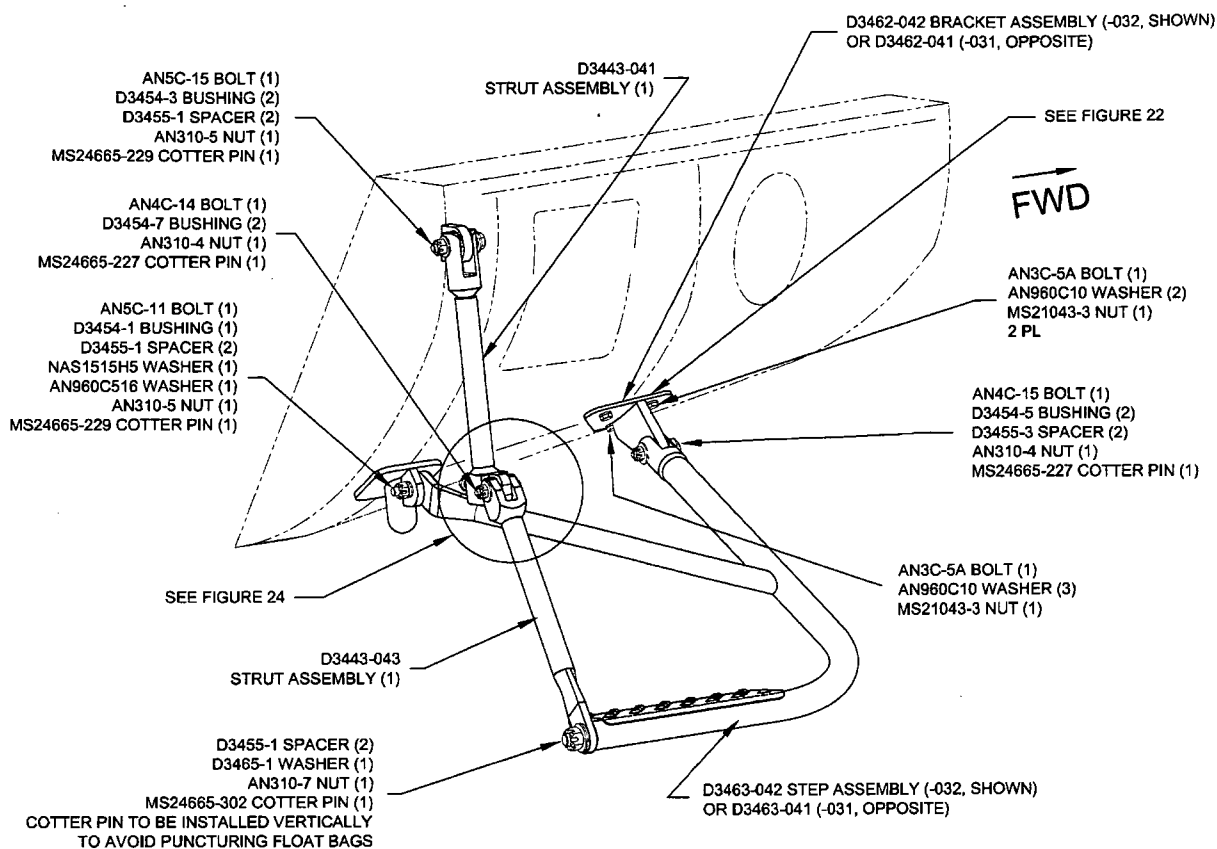


Washer

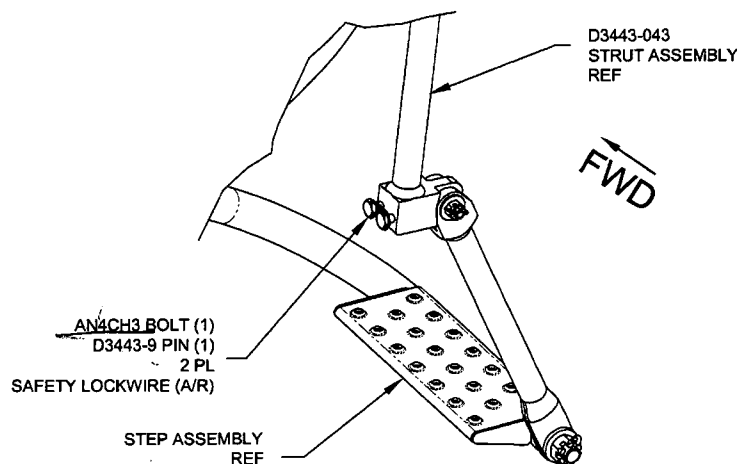
October 30, 2009 10:18:15 AM

Shop Packet Print

Page 11



**FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)**



**FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)**

• COPYRIGHT © 1996 BY DART AEROSPACE LTD. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **M**  
Date: 08.12.12

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
<del>1</del>	1	<del>D3443-041</del>	<del>STRUT ASSEMBLY</del>
<del>1</del>	1	<del>D3443-043</del>	<del>STRUT ASSEMBLY</del>
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
<del>2</del>	2	<del>D3454-7</del>	<del>BUSHING</del>
6 (4)	6	D3455-1	SPACER -2
2	2	D3455-3	SPACER
<del>1</del>		<del>D3462-041</del>	<del>BRACKET ASSEMBLY</del>
	1	D3462-042	BRACKET ASSEMBLY
1	1	D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
<del>1</del>	1	<del>D3465-1</del>	<del>WASHER</del>
2	2	AN310-4	NUT -1
2	2	AN310-5	NUT
<del>1</del>	1	<del>AN310-7</del>	<del>NUT</del>
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
<del>1</del>	1	<del>AN4C14</del>	<del>BOLT</del>
1	1	AN4C15	BOLT
<del>2</del>	2	<del>AN4CH3</del>	<del>BOLT</del>
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2 (1)	2	MS24665-227	COTTER PIN -1
2	2	MS24665-229	COTTER PIN
<del>1</del>	<del>1</del>	<del>MS24665-302</del>	<del>COTTER PIN</del>
1	1	NAS1515H5	WASHER

\* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP

53321